

D212-838-011 POD MODIFICATION KIT

(COMPATIBLE WITH D212-601-041/-042 HELI-UTILITY-POD)
(RH INSTALLATION SHOWN, LH INSTALLATION OPPOSITE)
(INSTRUMENTS NOT SHOWN FOR CLARITY)

NOTES:

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 20 lbs APPROX
 - 8) FOR INSTALLATION OF D4172-041 FRAME AND 80-005-3-8 INSERTS:
 - 8.1) LOCATE D4172-041 FRAME INSIDE POD SO THE FASTENER HOLES ARE MORE OR LESS ON THE CENTERLINE OF EACH D2200-3 POD RIBS;
 - 8.2) TRANSFER MARK AND DRILL SAME SIZE DIAMETER AS THE INSERT SHAFT DIAMETER TO A MAXIMUM OF 1.250" DEEP;
 - 8.3) CLEAN OUT FOAM CORE $\varnothing 0.125"$ TO $0.250"$ AROUND HOLE BETWEEN OUTER AND INNER SKINS;
 - 8.4) FOR EACH CAVITY, FILL ONE THIRD WITH "HYSOL EA394" OR EQUIVALENT EPOXY COMPOUND;
 - 8.5) INSTALL 80-005-3-8 INSERTS BY FILLING THE CAVITY WITH "HYSOL EA394" PER QSI 006 14.6 ENSURING INSIDE OF INSERTS ARE FREE OF POTTING COMPOUND;
 - 8.6) GRIND TO A SMOOTH SURFACE AS REQUIRED AFTER EPOXY HAS COMPLETELY CURED;
 - 8.7) TOUCH UP FINISH USING DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S.
 - 9) MOUNTING HOLE LOCATIONS FOR D4781-041 SHOULD BE CENTERED BETWEEN RIBS AT BOTTOM OF D2200-3 POD BASE.
 - 10) SEAL EDGES OF ALL DRILLED HOLES AND CUTOUTS WITH CYANOACRYLATE GLUE (CRAZY GLUE)
 - 11) WET INSTALL D4781-041/-1/-3 USING SIKAFLEX -241/-291 ADHESIVE
 - 12) IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND INSERT SHIMS AS REQUIRED BETWEEN THE POD RIBS AND D4172-041 FRAME.
MANUFACTURE 1.00" X 1.00" SHIMS TO REQUIRED THICKNESS FROM M6061T6S OR M6061T6B ALUMINUM
 - 13) FOR INSTALLATION OF D4813-1/-3 DOUBLERS ONTO POD LID:
 - 13.1) LOCATE D4813-1 DOUBLER INSIDE POD LID.
 - 13.2) TRANSFER MARK AND DRILL ALL HOLES THRU AS INDICATED IN VIEW K (ZN D6-4) EXCEPT QTY(6) $\varnothing 0.201$ SHOULD BE DRILLED TO $\varnothing 0.313$.
 - 13.3) CLEAN OUT FOAM CORE $\varnothing 0.125"$ TO $0.250"$ AROUND QTY(6) $\varnothing 0.313$ HOLE BETWEEN OUTER AND INNER SKINS;
 - 13.4) FILL EACH HOLE/CAVITY WITH "HYSOL EA394" OR EQUIVALENT EPOXY COMPOUND AND LET CURE;
 - 13.5) GRIND TO A SMOOTH SURFACE AS REQUIRED AFTER EPOXY HAS COMPLETELY CURED;
 - 13.6) DRILL QTY(6) $\varnothing 0.201$ HOLE THRU HARDENED "HYSOL EA394" OR EQUIVALENT EPOXY COMPOUND. DEBURR;
 - 13.7) TOUCH UP FINISH USING DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S.
 - 13.8) WET INSTALL D4813-1/-3 USING SIKAFLEX -241/-291 ADHESIVE

	ITEM	QTY -011	P/N	DESCRIPTION
		X	D212-838-011	POD MODIFICATION KIT
8	1	1	D4172-041	POD MOUNTING FRAME ASSY
	2	1	D4181-3	POD FRAME PLATFORM
	3	1	D4319-3	SPACER
	4	2	D4319-5	GPS BRACKET
	5	1	D4319-7	ALTIMETER BRACKET
	6	1	D4319-9	ALTIMETER BRACKET
	7	4	D4320-1	ANGLE BRACKET
11	8	2	D4781-041	DOUBLER ASSY
11	9	1	D4781-1	DOUBLER
11	10	1	D4781-3	DOUBLER
	11	1	D4781-5	DOUBLER
	12	1	D4782-041	PLATE ASSY
13	13	1	D4813-1	DOUBLER
13	14	1	D4813-3	DOUBLER
8	15	8	80-005-3-8	POTTED INSERT
	16	10	AN3-5A	BOLT
	17	6	AN3-10A	BOLT
12	18	8	AN4-4A	BOLT
	19	5	AN4-7A	BOLT
	20	4	AN4-12A	BOLT
	21	16	MS21042L3	NUT
	22	4	MS21042L4	NUT
	23	12	MS24694-S100	SCREW
	24	32	NAS1149D0363J	WASHER
	25	8	NAS1149F0432P	WASHER
	26	13	NAS1149D0463J	WASHER
12	27	A/R	N/A	SHIM

RELEASED
2013-04-02

A	NEW ISSUE	MB	13.03.15
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D212-838	REV. A SHEET 1 OF 1
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		TITLE POD MODIFICATION KIT	SCALE NTS
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D2200-1
POD LID

A
B4-2

OUTBD

AN3-10A BOLT
NAS1149D0363J WASHER, 2X
MS21042L4 NUT
13 6 PL

D4813-3 DOUBLER, NS
D4813-1 DOUBLER, FS
13

AN3-5A BOLT, FS
NAS1149D0363J WASHER, 2X
MS21042L4 NUT, NS
10 PL

D4781-3 DOUBLER, NS
D4781-1 DOUBLER, FS
11

DETAIL C B6-2
SCALE 3X

RELEASED
2013-04-02

D2200-3
POD BASE

FWD

B A5-2

D B1-2

C C1-2

SECTION A-A D8-2

D4181-3
POD FRAME PLATFORM

D4319-5 GPS BRACKET
AN4-7A BOLT, 2X
NAS1149D0463J WASHER, 2X
2 PL

D4320-1 ANGLE BRACKET
AN4-7A BOLT
NAS1149D0463J WASHER
4 PL

D4781-041 DOUBLER
2 PL 11

AN4-12A BOLT
NAS1149D0463J WASHER
4 PL

D4319-7
ALTIMETER BRACKET

D4319-3
SPACER

D4181-3
POD FRAME
PLATFORM
REF

D4781-5
DOUBLER

MS21042L4 NUT
NAS1149D0463J WASHER
4 PL

D4319-9
ALTIMETER BRACKET

DETAIL D B7-2
SCALE 3X

MS24694-S100
SCREW
4 PL

D4782-041
PLATE ASSY

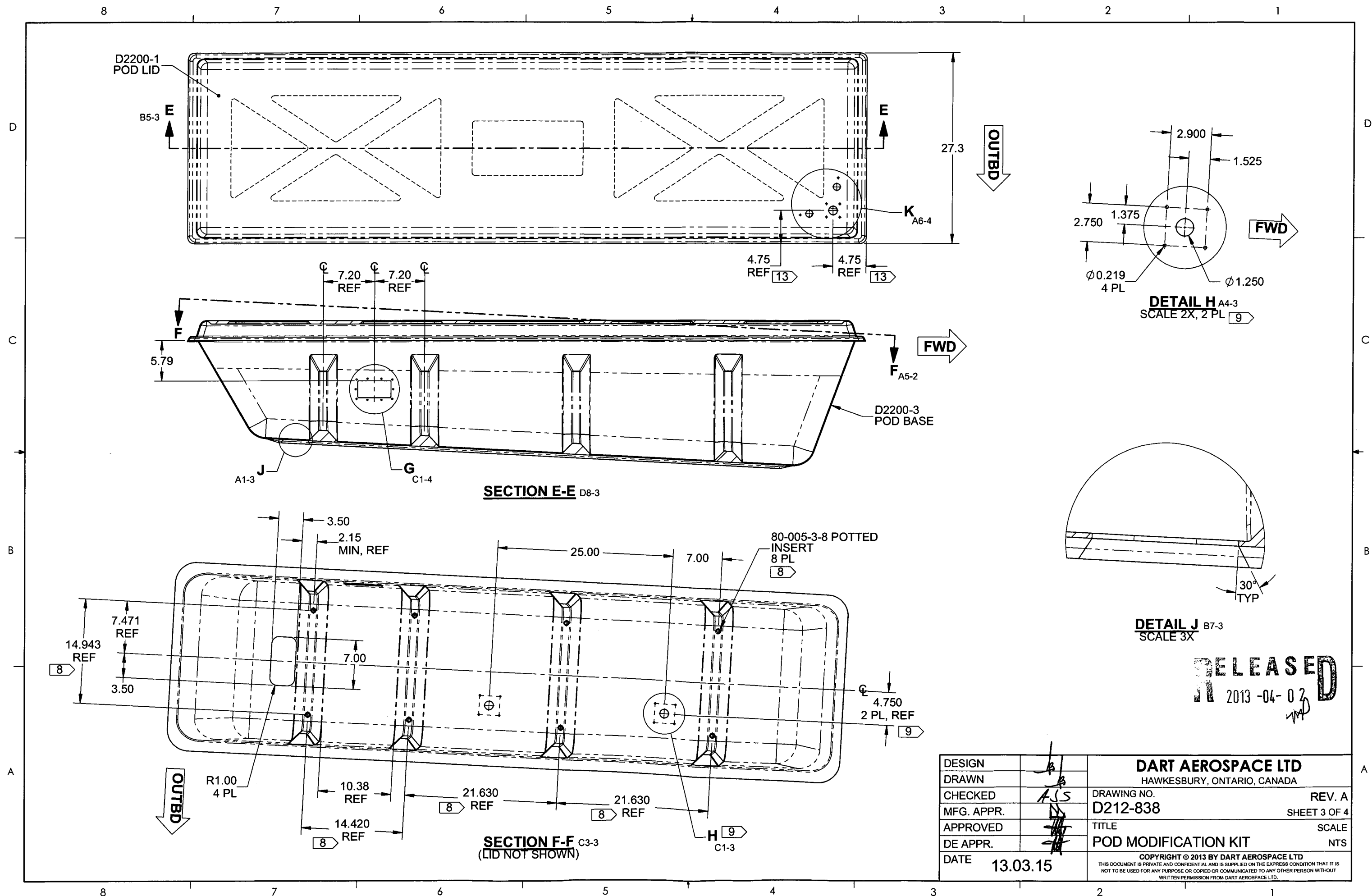
MS24694-S100
SCREW
8 PL

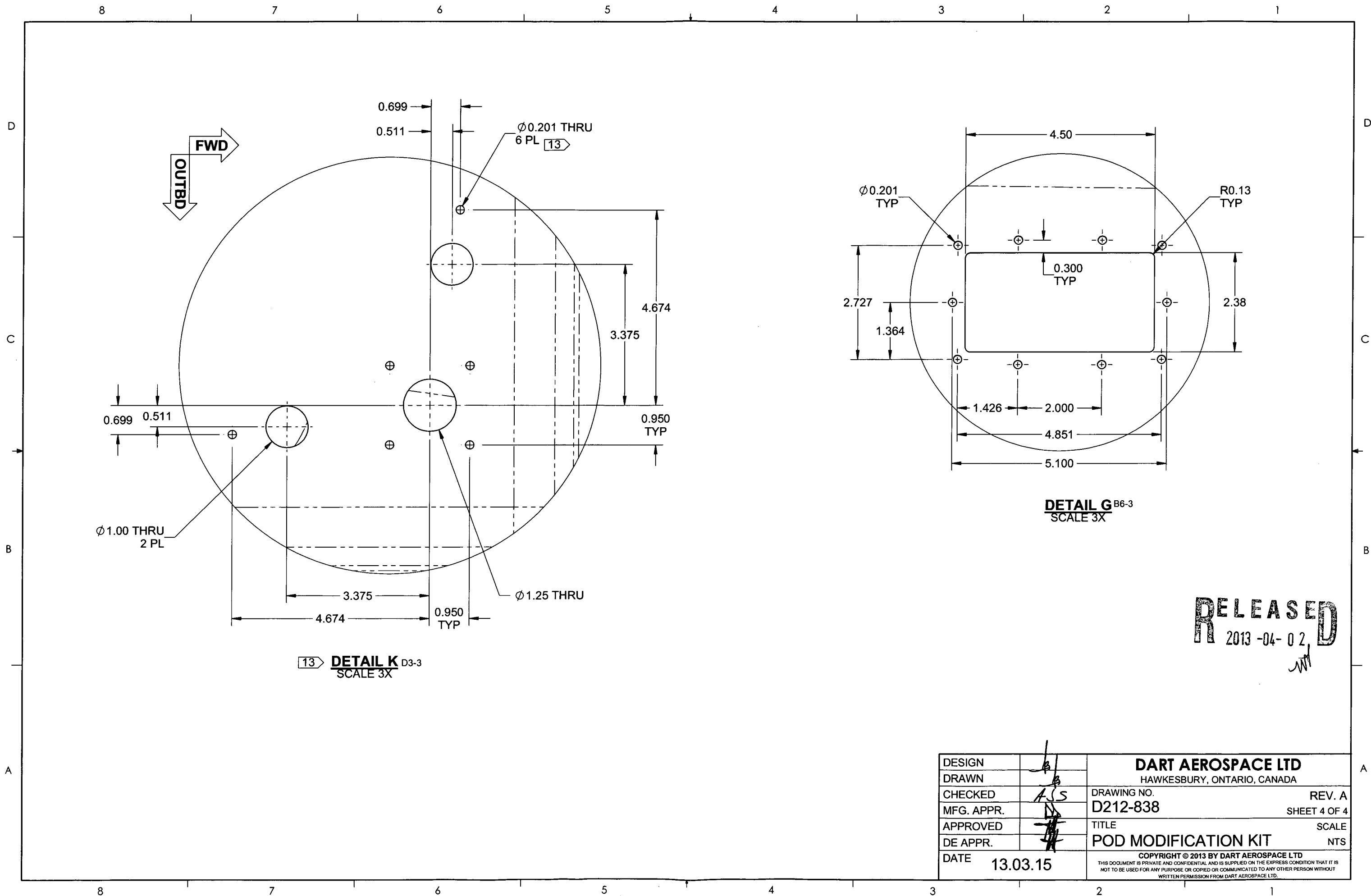
AN4-4A BOLT
NAS1149F0432P WASHER
8 PL 12

SECTION B-B C3-2
(LID NOT SHOWN)

OUTBD

DESIGN	B	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	DA	D212-838	SHEET 2 OF 4
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